

Work Order ID 141763

Thursday, February 11, 2016 10:23:24 AM

141763

Page 1

Item ID: D350-600-242

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/18/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: FEB 11 2016

Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9639	A								
DSI9701	<i>abg</i>								
IIN D350-600	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels as per PPP D350-600-242 CHG002								
110	Small Fab	0.00							
110	Small Fab	0.05							
Small Fab	Memo								
	1-Drill holes in D3188-2 using drill jig DT8971								
	2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188								
	3-Deburr								
	4-Install inserts in D3188-2 as per Dwg D3188.								

DART ID: D3188-2P

FDC ID: DAE013-003

Lot #: 2016-05-09

4
DAS
21
9-89

OCT 14 2016

OCT 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

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Item ID: D350-600-242

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/18/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							16 9-89
120									
QC	Memo	0.00							10/10/14
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							OCT 14 2016
Small Fab	****This step seperates hardware, previous steps is for body & floor****								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 141763

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Item ID: D350-600-242 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacepod™ Fwd Opening RH AS350 / AS355
Start Date: 2/11/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/18/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Small Fab	0.00							
150	Small Fab	0.05							
Small Fab	Memo								
	Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600								
	Hardware on previous steps is for door ass'y*								
	1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight. Install insert.								
	A/R Hysol batch: <u>13528</u> expire date: _____								
	A/R Milled fibres batch: _____								
	2- Prime (grey) as necessary per QSI005								
	Primer batch: <u>135778</u>								
	Hardner batch: <u>135778</u>								
170	QC5- Inspect part completeness to step on W/O	0.00							
170	QC	0.00							
Quality Control	Memo								

DAS
16
9-89

10/10/14

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WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

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Item ID: D350-600-242 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacepod™ Fwd Opening RH AS350 / AS355
Start Date: 2/11/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/18/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M135310 Memo Wing Walk Spacepod top surface of Pod as per Dwg D3188	0.00 0.00				1R+1	d	16/10/13	
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							DAS 16 9-89 16/10/14
200 *200* Packaging Packaging	Pick Kit Memo	0.00 0.00	DAS 16 9-89 16/10/14			DAS 6 9-89		OCT 18 2016	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 141763***141763***

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Thursday, February 11, 2016 10:23:24 AM

Item ID: D350-600-242 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacepod™ Fwd Opening RH AS350 / AS355
Start Date: 2/11/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/18/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC4- 100% Inspect kits for completeness	0.00							
210									
QC	Memo	0.00							
Quality Control									
220		0.00							
220	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-600-242								
	Location: _____								
	PPP Rev: _____ sold								
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

SMB
10/10/14

SMB
10/10/14

DAS
21
9-89

DAS
21
9-89

OCT 14 2016**OCT 14 2016**

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 141763

141763

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.03.07 new issue EC
 IPP rev B 07.04.16 reformat, D3188 rev.E EC
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove
 D3188-2m add D3188-6 DD 10.04.07 verified
 by:JLM IPP REV:F
 13.02.06 AS PER DSI9639 REV.A DD VERF:JLM IPP REV:G 14.07.30
 as per DSI9701 rev.a DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-6A Bolt		Purchased	No				Each	351.0000		7			
AN3-6A ** 134955 DAS 6 9-89 OCT 14 2016													
				<u>Location</u>				<u>Loc Qty</u>					
				over003				300					
				M133932				125					
				M134055				175					
				ST349				51					
				M133561				51					
D2985 Label		Manufactured	No				Each	11.0000		1			
D2985 ** DAS 6 9-89 OCT 14 2016													
				<u>Location</u>				<u>Loc Qty</u>					
				ST014				11					
				131782				11					
D2985-3 Decal, RH Install		Manufactured	No				Each	5.0000		1			
D2985-3 ** DAS 6 9-89 OCT 14 2016													
				<u>Location</u>				<u>Loc Qty</u>					
				ST014				5					
				137700				5					

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

D3015-3

Manufactured No

Each

208.0000

1

DAS

D3015-3

**

B150873 x1

16
9-89

Locknut

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

40

136803

15

140018

25

ST025A

150

140771

50

141459

100

D5127-1

Manufactured No

Each

28.0000

2

DAS

D5127-1

**

B127406 x2

16
9-89

Shim, Large

Location

Loc Qty

Loc Code

ST153

28

127406

8

128839

20

D5127-3

Manufactured No

Each

28.0000

2

DAS

D5127-3

**

B127632 x2

16
9-89

Shim, Small

Location

Loc Qty

Loc Code

ST153

28

127632

8

128941

20

D3188-6

Manufactured No

110

Each

0.0000

1

1

DAS

D3188-6

**

141766

OCT 12 2016

6
9-89

Spacepod Body

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 3

Work Order ID: 141763

141763

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

AN526C832R24

Purchased No

140

Each

74.0000

4

4

AN526C832R24

screw

M124255 x4

DAS
16
9-89

Location

Loc Qty

Loc Code

ST327

74

118870

8

124255

66

D2179

Manufactured No

140

Each

22.0000

2

2

D2179

Hinge Bracket Plate

B106233 x2

DAS
16
9-89

Location

Loc Qty

Loc Code

ST003

21

106233

21

ST004

1

35432

1

D2237

Manufactured No

140

Each

10.0000

2

2

D2237

Striker Plate

B145516

DAS
16
9-89

Location

Loc Qty

Loc Code

ST004

10

136090

10

D3538-1

Manufactured No

140

Each

5.0000

2

2

D3538-1

Hinge Bracket

B141380 x2

DAS
16
9-89

Location

Loc Qty

Loc Code

FG

4

115602

2

130855

2

ST041

1

130855

1

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 4

Work Order ID: 141763

141763

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

D3554-7

Manufactured No

140

Each

8.0000

1

1

DAS

16

9-89

D3554-7

Ball Stud

**

B142010 x1

Location

Loc Qty

Loc Code

FG

5

87039

5

ST049

3

87571

3

D3567-2

Manufactured No

140

Each

12.0000

1

1

DAS

16

9-89

D3567-2

Decal

**

B129799 x1

Location

Loc Qty

Loc Code

ST043

12

129799

11

50375

1

MS20426AD4-5

Purchased No

140

Each

2,122.000

4

4

DAS

16

9-89

MS20426AD4-5

RIVET

**

M133751 x4

Location

Loc Qty

Loc Code

GA

1522

m133751

1522

ST312

600

m133751

600

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, February 11, 2016 10:23:28 AM

Page 5

Work Order ID: 141763

141763

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

140

Each

1,240.000

1

1

NAS1149D0563.J

Washer

M135470 +1

DAS

16

9-89

16/10/14

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

900

m133769

400

m133990

500

ST263

184

m133363

14

m133938

170

ST269

103

m128257

103

NAS1149DN832J

Purchased

No

140

Each

2,255.000

20

20

NAS1149DN832.J

Washer

M135470 M131697 x 20

DAS

16

9-89

16/10/14

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST260a

1500

M134180

1500

ST263

671

M131697

671

ALS4-1032-130

AELS4-1032-130

Purchased

No

150

Each

1,611.000

28

28

ALS4-1032-130

Rivnut

M128649

DAS

29

9-89

16.10.14

Location

Loc Qty

Loc Code

FP001

1611

M133077

1611

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 141763

141763

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

AN526C832R10

Purchased

No

150

Each

65.0000

10

10

AN526C832R10

Screw

**

OCT 14 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST327

65

m127363

65

AN526C832R14

Purchased

No

150

Each

170.0000

2

2

AN526C832R14

Screw

**

OCT 14 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST327

170

124215

20

m133932

150

D2228

Manufactured

No

150

Each

36.0000

4

4

D2228

Backing Plate

**

OCT 12 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST004

7

95704

7

ST012a

29

105984

29

D2464

Manufactured

No

150

f

789.4495

10.8

11.36842

D2464

Neoprene Seal (\$per foot)

**

OCT 12 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST409

789.4494737

121946

789.449474

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

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Work Order ID: 141763

141763

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

D2585

Manufactured No

150

Each

23.0000

2

2

D2585

Latch Clamp

**

146078

DAS

6
9-89

Location

Loc Qty

Loc Code

ST008

23

139075

23

D2586

Manufactured No

150

Each

97.0000

2

2

D2586

Door Latch

**

144160

DAS

6
9-89

Location

Loc Qty

Loc Code

FG

12

119746

1

138048

2

139228

9

ST481

35

139228

35

ST488a

50

140535

25

141454

25

D2621

Manufactured No

150

Each

26.0000

2

2

D2621

Latch Plate

**

141106

OCT 12 2016

DAS

6
9-89

Location

Loc Qty

Loc Code

FG

2

88616

2

ST012a

24

127749

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 141763

141763

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

D2857-1

Manufactured No

150

Each

18.0000

1

1

D2857-1

Hinge Bracket

**

144745

OCT 1 2 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

5

121829

2

82261

2

91914

1

ST012

13

121829

1

133964

12

D2857-2

Manufactured No

150

Each

16.0000

1

1

D2857-2

Hinge Bracket

**

174616

OCT 1 2 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

5

130848

2

78904

3

ST012

11

133903

11

D3557-1

Manufactured No

150

Each

11.0000

1

1

D3557-1

Bracket

**

OCT 1 2 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST049

11

125281

1

126308

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Work Order ID: 141763

141763

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

150

Each

1,772.000

18

18

MS21042L 08

Nut

135566X16

DAS
6
9-89

OCT 12-2016

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

275

m133134

3

m134063

272

OVER007

500

m134063

500

ST303

896

m133922

896

MS21042L3

Purchased

No

150

Each

2,175.000

2

2

MS21042L 3

Nut

135600

DAS
6
9-89

OCT 12 2016

Location

Loc Qty

Loc Code

FP001

163

m133790

163

GA

162

m133790

162

ST304

1850

m134039

1850

MS27039-08-11

Purchased

No

150

Each

460.0000

2

2

MS27039-08-11

SCREW

131676

DAS
6
9-89

OCT 12 2016

Location

Loc Qty

Loc Code

over006

450

m133769

450

ST278

10

m133363

10

Thursday, February 11, 2016 10:23:28 AM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, February 11, 2016 10:23:28 AM

Page 10

Work Order ID: 141763

141763

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15

Purchased

No

150

Each

486.0000

2

2

MS27039-1-15

Screw

**

M134852

DAS

OCT 12 2016

6
9-89

Location

Loc Qty

Loc Code

GA

21

m127916

21

ST280

465

m132640

465

NAS1149D0363J

Purchased

No

150

Each

1,597.000

2

2

NAS1149D0363J

Washer

**

135297

DAS

OCT 12 2016

6
9-89

Location

Loc Qty

Loc Code

GA

64

m130799

64

ST260a

1000

m134055

1000

ST263

533

m133790

35

m133932

498

NAS1515H3

Purchased

No

150

Each

346.0000

2

2

NAS1515H3

Washer

**

OCT 12 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

10

123301

10

GA

38

m129521

38

ST266

298

m128635

7

m131697

291

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Page 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

Thursday, February 11, 2016 10:23:28 AM

Page 11

Work Order ID: 141763

141763

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS350 / AS355

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

D350-600-449

Manufactured No

200

Each

2.0000

1

1

D350-600-449

Switch Relocation

DAS
27
9-89

Location

Loc Qty

Loc Code

FG125

2

132506

1

137505

1

OCT 14 2016

14 ~~14~~ 6 DAS
1-5666 6 9-89

OCT 12 2016
28 9-89

K10021

Manufactured No

200

Each

1.0000

1

1

K10021

Spacepod Hardware (-241)

DAS
27
9-89

Location

Loc Qty

Loc Code

FG125

1

134942

1

182459 OCT 12 2016
B143459 DAS 28 9-89

D3186-4

Manufactured No

110

Each

0.0000

1

1

D3186-4

Spacepod Door, RH

D3187-2

Manufactured No

110

Each

1.0000

1

1

D3187-2

Floor Panel

137507 DAS 6 9-89
129929 DAS 6 9-89
OCT 12 2016

Location

Loc Qty

Loc Code

ST400

1

127574

1

OCT 14 2016

A3235-020-935

Purchased No

110

Each

50.0000

8

8

A3235-020-935

Washer, Countersunk

Location

Loc Qty

Loc Code

ST548

30

106150

30

ST554

20

m133932

20

OCT 12 2016
DAS 6 9-89

Thursday, February 11, 2016 10:23:28 AM

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Page 11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART SERVICE INSTRUCTION

TO AMEND IIN-D350-600 REV. E OR EARLIER

AND ICA-D350-600 REV. 5 OR EARLIER

REF TCCA STC: SH93-88

REF FAA STC: SR00098NY/SR00099NY

REF EASA STC: EASA.IM.R.S.01292

1.0 PURPOSE:

IT HAS COME TO DART'S ATTENTION THAT THE INFORMATION SHOWN ON D2985 DECAL CAN BE MISINTERPRETED WHEN ONLY A LH OR RH SPACEPOD IS INSTALLED ON AN AIRCRAFT. THEREFORE, THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO ADD THE D2985-1/-3 DECALS AS OUTLINED BELOW.

2.0 INSTRUCTIONS:

IT IS ACCEPTABLE TO REPLACE D2985 WITH D2985-1/-3 AS FOLLOWS:

D2985-1: FOR LH INSTALLATIONS ONLY (REF. D35X-600-141/-143/-241/-243)

D2985-3: FOR RH INSTALLATIONS ONLY (REF. D35X-600-142/-242)

3.0 PARTS LIST

QTY -141	QTY -142	QTY -143	QTY -241	QTY -242	QTY -243	PART NUMBER	DESCRIPTION
X						D350-600-141	SPACEPOD... LH, AS350
	X					D350-600-142	SPACEPOD... LH, AS350/AS355
		X				D355-600-143	SPACEPOD... LH, AS355
			X			D350-600-241	SPACEPOD... LH, AS350
				X		D350-600-242	SPACEPOD... LH, AS350/355
					X	D355-600-243	SPACEPOD... LH, AS355

1	1	1	1	1	1	D2985	DECAL
1		1	1		1	D2985-1	LH DECAL (ADD)
	1			1		D2985-3	RH DECAL (ADD)

4.0 WEIGHT AND BALANCE

NO CHANGE.

5.0 MAINTENANCE:

MAINTAIN D2985-1/-3 PER ITEM 5.2.7 OF ICA-D350-600.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: D. Shepherd
D. SHEPHERD (DE # 02)

DATE: 12.12.07
CERT. NO.: SH93-88
ISSUE NO.: 6

16-02-11
NO. 141763M5
WORK ORDER
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A	NEW ISSUE	SFM	12.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SFM	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9639	SHEET 1 OF 1
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DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-600 REV E AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-600 REV 5**
REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY and SR00099NY
REF. EASA STC EASA.IM.R.S.01292

1.0 PURPOSE

In response to customer feedback, Dart is implementing changes designed to ease the mounting of hinge brackets for the forward opening Spacepod and to improve the security of the hinge assemblies. The purpose of this DSI is to introduce the DSI 9701-011 Hinge Shim Kit and to provide instructions and parts lists to install and assemble the hinges on Dart Spacepods D350-600-241/-242/-243/-247/-248/-249. One Kit is required per door.

2.0 PROCEDURE

- 2.1 Remove the D3186-3/-4 Spacepod Door by disconnecting the hinges.
- 2.2 Remove the D3538-1 Hinge Brackets and D2179 Hinge Bracket Plates. Retain all parts.
- 2.3 Re-install the D3538-1 Hinge Brackets with the D5127-3 Shims between the Spacepod and Hinge Bracket using the existing mounting holes and fasteners. See Figure 1. The D3538-1 Hinge Brackets should be oriented as per Table 1. It may be necessary to reverse the orientation, as required, on some Spacepod bodies. Furthermore, due to normal variations in the Spacepod geometry, additional shimming may be required. It is acceptable to use Hysol Liquid Shim, thin washers or shims fabricated from 6061-T6 aluminum for this purpose.
- 2.4 Torque fasteners to 9-12 in-lbs (1-1.4 N-m).

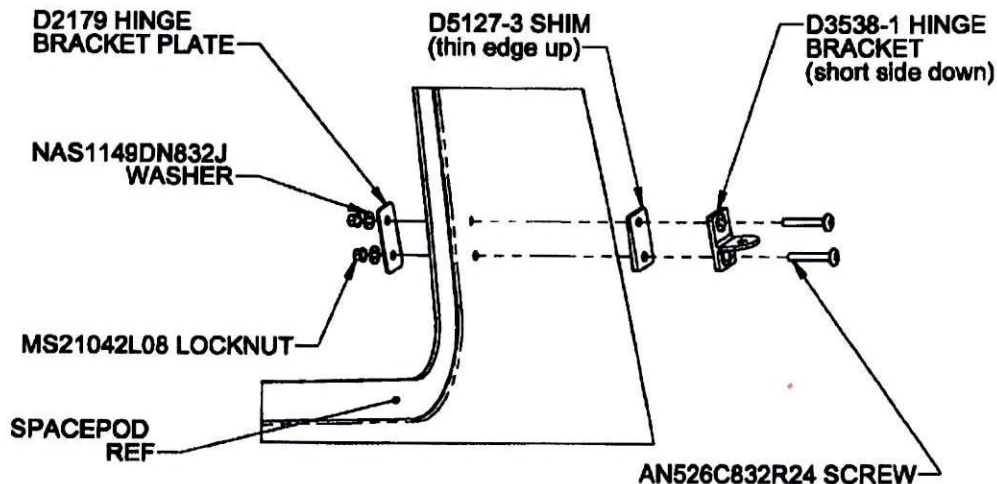


FIGURE 1: SPACEPOD HINGE INSTALLATION
(LOWER HINGE, RH DOOR SHOWN)

SPACEPOD	UPPER D3538-1 BRACKET	LOWER D3538-1 BRACKET
RIGHT SIDE	SHORT SIDE UP	SHORT SIDE DOWN
LEFT SIDE	SHORT SIDE DOWN	SHORT SIDE UP

TABLE 1: D3538-1 HINGE ORIENTATION

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	14.09.09
CERT. NO.:	SH93-88
ISSUE NO.:	6

B	ADD NOTES ALLOWING USE OF ADDITIONAL SHIM MATERIALS, ALTERNATE SHIM ORIENTATION	DB	14.09.09
A	NEW ISSUE	DB	14.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	13	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9701	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE SHIM KIT	NTS
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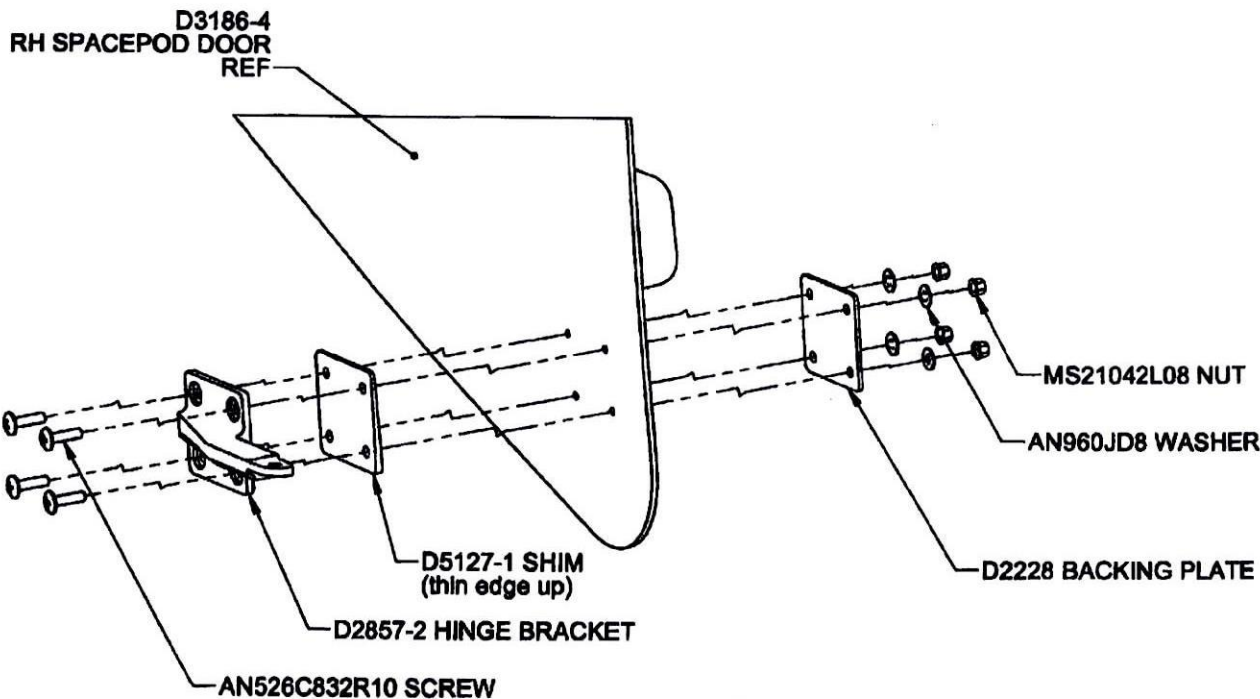


FIGURE 2: SPACEPOD DOOR HINGE INSTALLATION
(LOWER HINGE, RH DOOR SHOWN)

- 2.5 Remove the D2857-1/2 Hinge Brackets and D2228 Backing Plates. Retain all parts and fasteners.
- 2.6 Re-install the D2857-1/2 Hinge Brackets with the D5127-1 Shim between the Spacepod Door and Hinge Brackets, using the existing mounting holes and fasteners. See Figure 2. The hinge brackets should be installed as shown in Table 2. Shims can be re-oriented, as required, to provide the best mounting configuration. Furthermore, due to normal variations in the Spacepod geometry, additional shimming may be required. It is acceptable to use Hysol Liquid Shim, thin washers or shims fabricated from 6061-T6 aluminum for this purpose.
- 2.7 Torque fasteners to 9-12 in-lbs (1-1.4 N-m).
- 2.8 Re-install the D3186-3/4 Spacepod Door onto the Spacepod per Section 52.4 of ICA-D350-600. See Figure 3 for reference.

DOOR	UPPER HINGE BRACKET	LOWER HINGE BRACKET
RIGHT SIDE	D2857-1	D2857-2
LEFT SIDE	D2857-2	D2857-1

TABLE 2: HINGE SELECTION CHART

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	3	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9701	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE SHIM KIT	NTS
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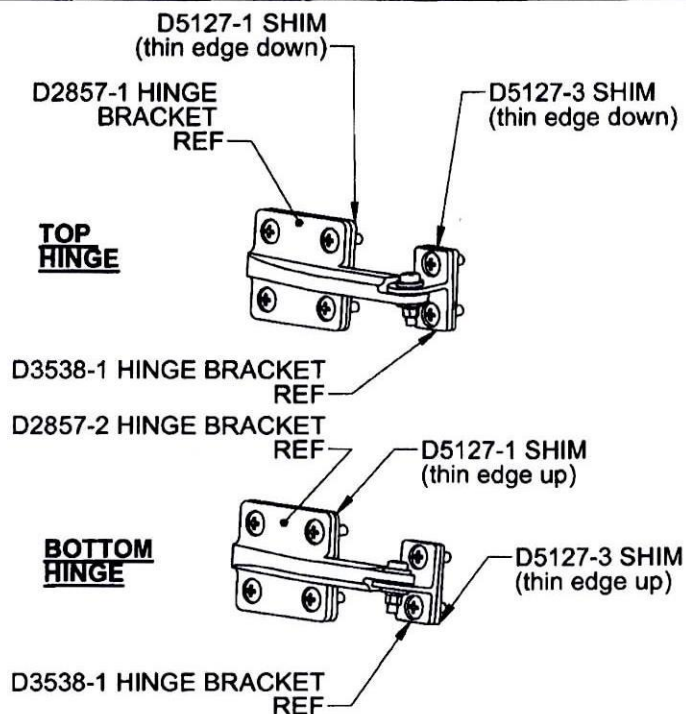


FIGURE 3: DSI 9701-011 HINGE KIT ASSY
(RH DOOR ASSY SHOWN, LH OPPOSITE)

3.0 PARTS LIST

QTY -011	P/N	DESCRIPTION
X	DSI 9701-011	HINGE SHIM KIT
2	D5127-1	SHIM, LARGE
2	D5127-3	SHIM, SMALL

4.0 WEIGHT AND BALANCE

There is no Weight and Balance change associated with this update.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9701	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE SHIM KIT	NTS
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